

Date: Wednesday, 25/06/2008 10:02:04 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: UPPER RESTRAINT WELDMENT	
Job Number	: 40064		^ Part Number	: PB674300131	
Estimate Number	: 13398		Drawing Number	: B6743001 P.41/ P.43	
P.O. Number	:		Project Number	: N/A	
This Issue	: 25/06/2008	S.O. No. :	Drawing Revision	: B1	
Prsh Rev.	: NC		Material	:	
First Issue	: / /	Type : SMALL /MED FAB	Due Date	: 04/07/2008	Qty: <i>5</i> Um: Each
Previous Run	:		split		
Written By	:				
Checked & Approved By	: <u>JUL 08. 0.25</u>				
Comment	: Est Rev:A 08-06-20 new issue DD verified by:ec				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S090	6061-T6 .090 Sheet
Comment: Qty.: 0.4557 sf(s)/Unit Total : 2.2785 sf(s) 6061-T6 .090 Sheet batch: <u>108595</u> <u>HB 8-7-15</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg B67-43001 - 321 <u>HB 8-7-15</u> <u>06.06.25</u> Dwg Rev: <u>B1</u> <u>HB 8-7-15</u> Prog Rev: <u>B1</u> ***grain direction along 25.00" *** 2-Deburr if necessary <u>HB 8-7-15</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <u>HB 8-7-15</u>
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK <u>S 08/7/15 (+6)</u>
Comment: SECOND CHECK		
5.0	BRAKE NC	NC BRAKE <u>SB 08/07/16 (+6)</u>
Comment: NC BRAKE Bend as per Dwg B67-43001		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/06/2008 10:02:04 AM
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Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



S 08-07-16 (X6)

Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

(X6) 08/07/16 (6D)

8.0 POWDER COATING POWDER COATING



MA102316

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME: 7:10 AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 7:40 AM

08-07-17

(X6) (6)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



(X6) 08-07-17

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 PB674300133 Upper Pad Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Upper Pad Assembly

batch: 102316

08-08-26

11.0 NAS1149F0316P WASHER



Comment: Qty.: 5.0000 Each(s)/Unit Total: 25.0000 Each(s)

WASHER

batch: 102316

08-08-26

12.0 MS27039109 Screw



Comment: Qty.: 5.0000 Each(s)/Unit Total: 25.0000 Each(s)

Screw

batch: 102316

08-08-26

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg B67-43001

11/08/08 24 5

14.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

11/08/08 24 5

16.0 QC21

FINAL INSPECT

RELEASE



08/08/08 24 5

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



11/08/08 24 5

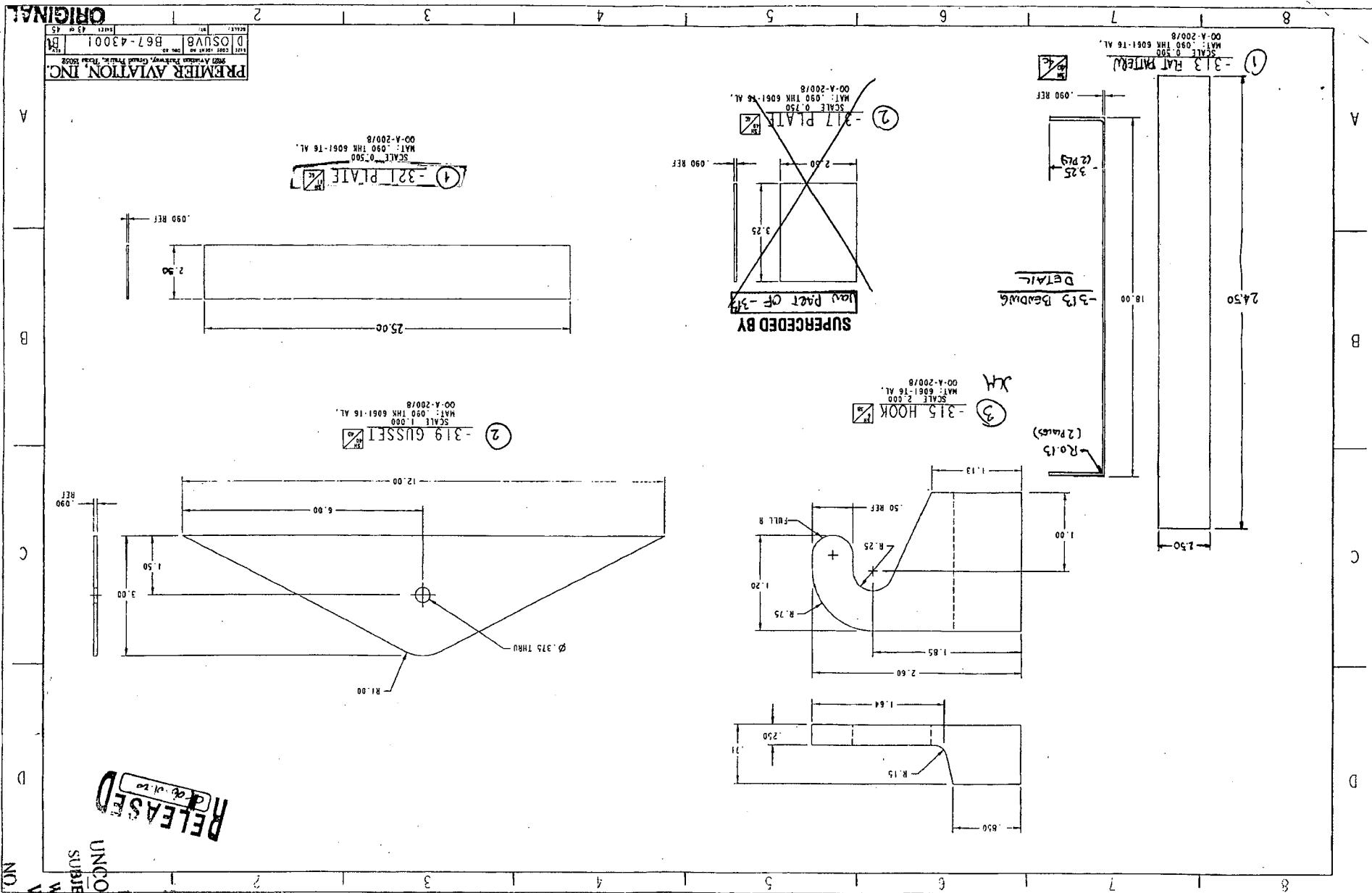
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



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 WITHOUT NOTICE
 WORK ORDER NO. 400

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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DART AEROSPACE LTD	Work Order:	40064
Description: UPPER RESTRAINT WELDMENT	Part Number:	PB6743001-3
Inspection Dwg:	Rev: 6	Page 1 of 1

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FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	N
Date:	8-7-15	Date:	08/07/15	Date:	g

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

H:\FORMS\Quality Assurance\approved QA\FAI revD

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